

Date: Wednesday, 6/6/2007 3:45:53 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 32840				
Estimate Number	: 10493				
P.O. Number	: N/A		Part Number	: D32043	
This Issue	: 6/6/2007 S.O. No. : N/A		Drawing Number	: D3204 REV. A1	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A1	
Previous Run	: 30895		Material	: N/A	
Written By			Due Date	: 6/27/2007 Qty: 6 Um: Each	
Checked & Approved By					
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X02000	6061-T6 Bar .50" x 2.0"	
		Comment: Qty.: 0.5815 f(s)/Unit Total : 3.4889 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Batch: <i>7103755</i>	<i>7103755</i> <i>7/07/08/28</i> 6
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)	<i>7/07/08/28</i> 6
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA344 and Dwg D3204 2- Deburr Identify as D3204-3	<i>7/07/08/28</i> 6
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>7/07/08/28</i> 6
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>7/07/08/28</i> 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/08/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

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Part Number: D32043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 07/08/29 (6)*

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/08/29 (6)*

Job Completion



*U 07/08/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32840
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article Prototype

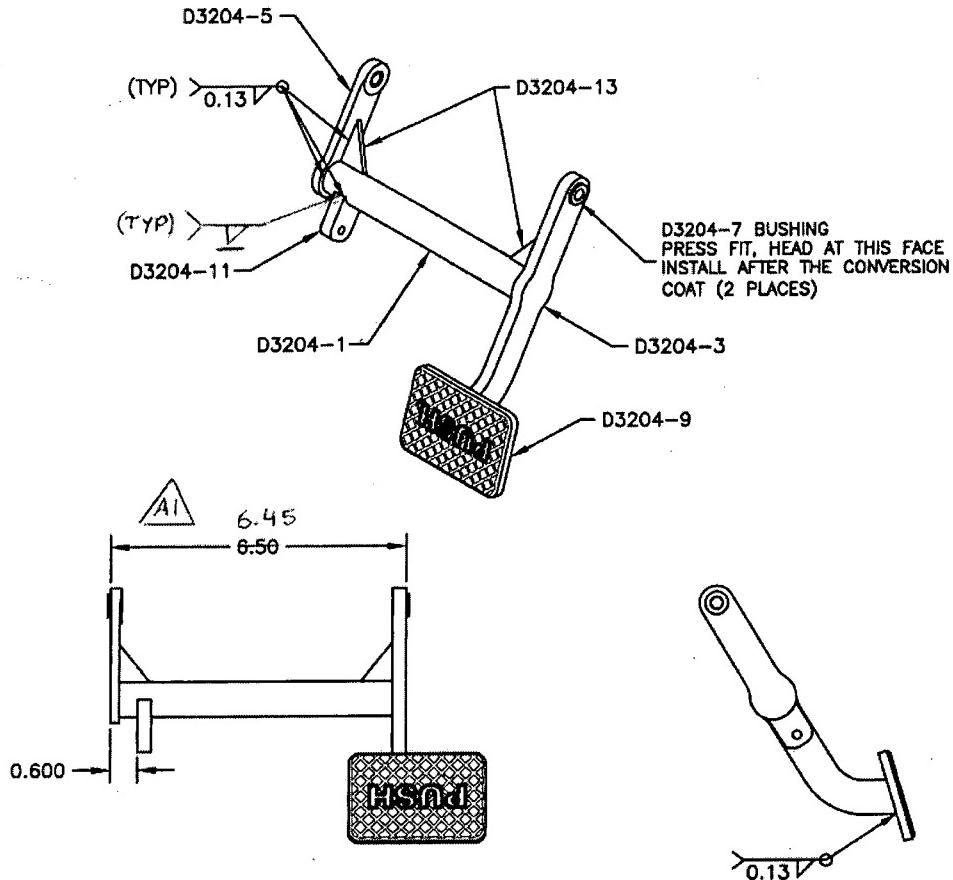
Measured by:	<u>JMK</u>	Audited by:	<u>SC</u>	Prototype Approval:	N/A
Date:	07/08/28	Date:	07.08.28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>
B	06.03.21	Dwg Rev update	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

**RELEASED**  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

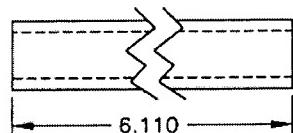
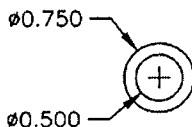
#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

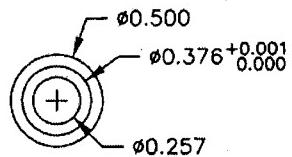
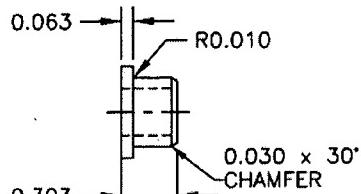
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WORK ORDER  
NO. 32840

**DART**

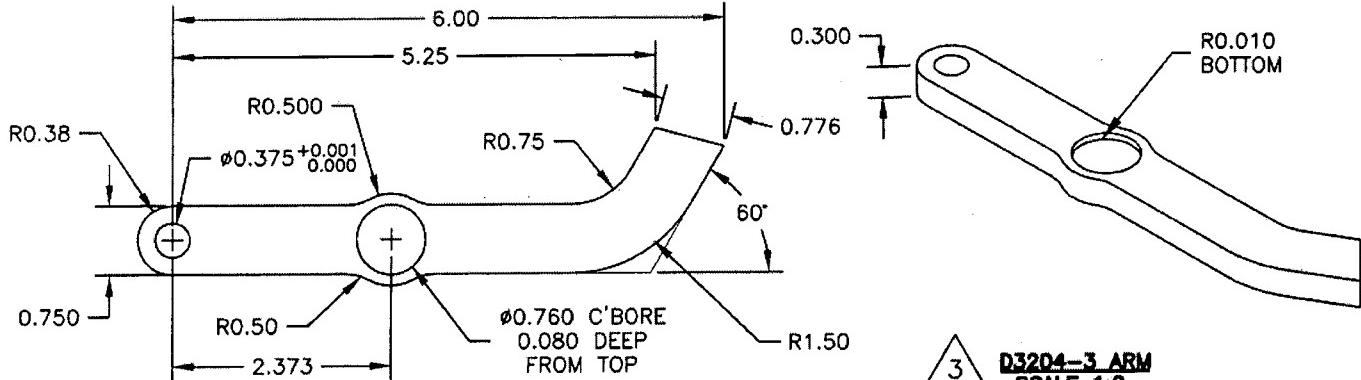
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CHECKED <i>RT</i>	APPROVED <i>RT</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

**RELEASED**  
04.04.05 #

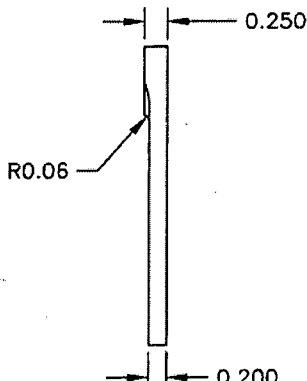
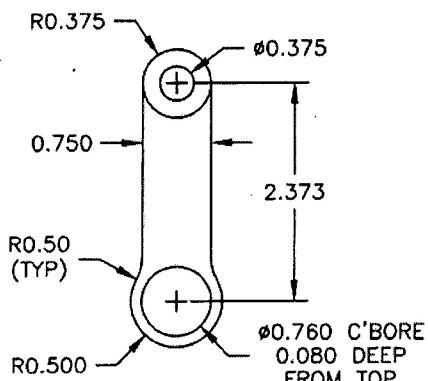
2 D3204-1 TUBE  
SCALE 1:2



4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2

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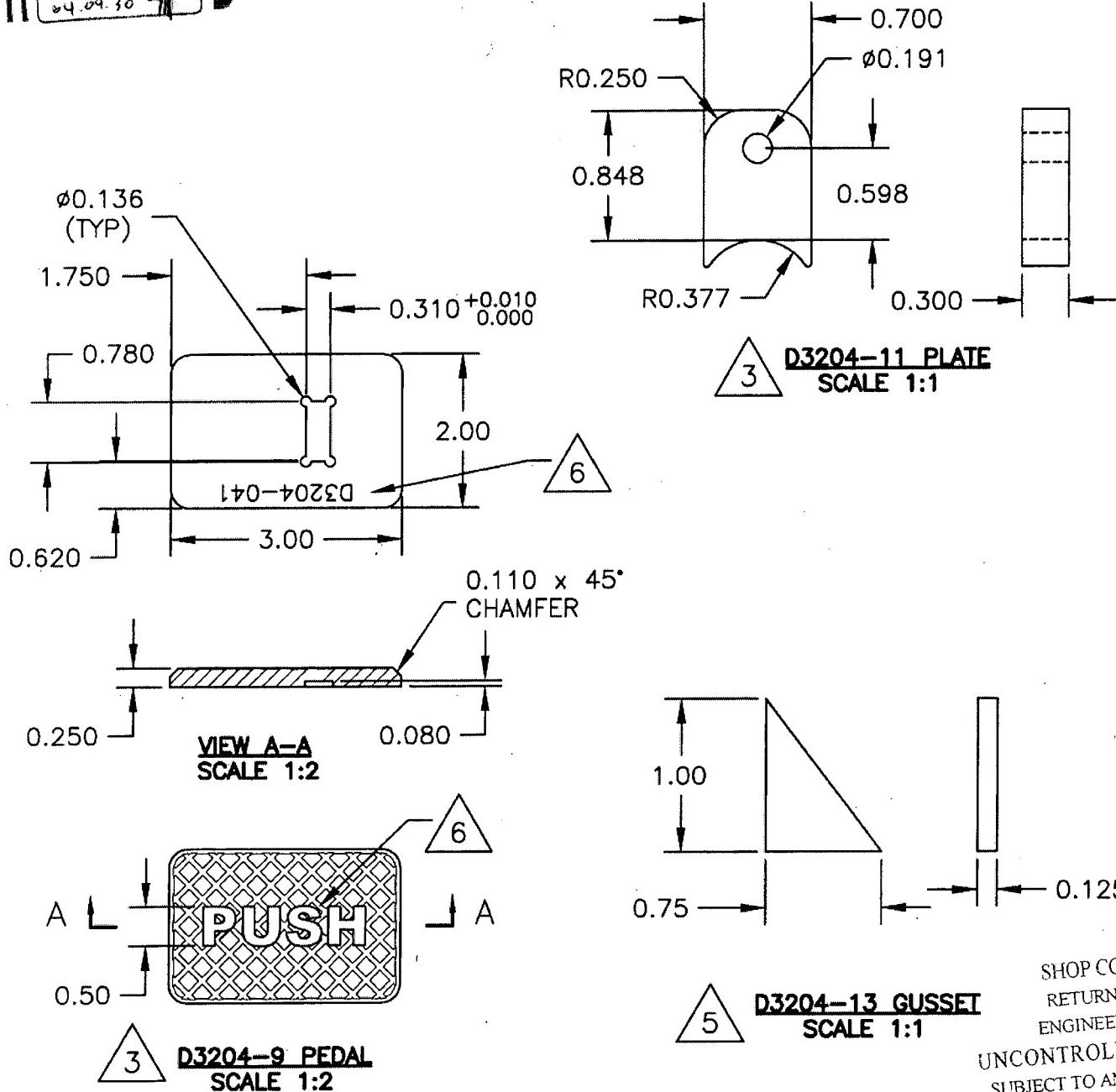
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3204	REV. A SHEET 3 OF 3	
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS	

RELEASED  
24.09.30 ~~F~~



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